

Date: Monday, 11/21/2005 7:41:48 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 3" OUTER TUBE	
Job Number	: 24841				
Estimate Number	: 10796				
P.O. Number	: N/A		Part Number	: D26001240	
This Issue	: 11/21/2005 S.O. No. : N/A		Drawing Number	: D2600 REV D1	
Prsh Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: D1	
Previous Run	: N/A		Material	: N/A	
Written By	: SEE COMMENT BELOW		Due Date	: 12/15/2005 Qty: 50 Um: Each	
Checked & Approved By	: SEE REVERSE SIDE FOR DATE				
Comment	: Est Rev:A 99.08.18 Was 2600-1 added -240 for length EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 Comment: PURCHASING 2008933 Issue P/O: PO 0000073 AB 05/11/25 a) Extrude as per Dwg D2600 (240" long) b) Material: 6061-T6 c) Tool: MH-18870 OR BON L #897121 d) Material certification is required.
2.0	D26001240	Extrusion Round 3" 206
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Extrusion Round 3" 206
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached C 205/12/15 59
4.0	QC6	DIMENSIONAL CHECK
		 Comment: DIMENSIONAL CHECK J 06-12 59
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: J 06-12 59

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

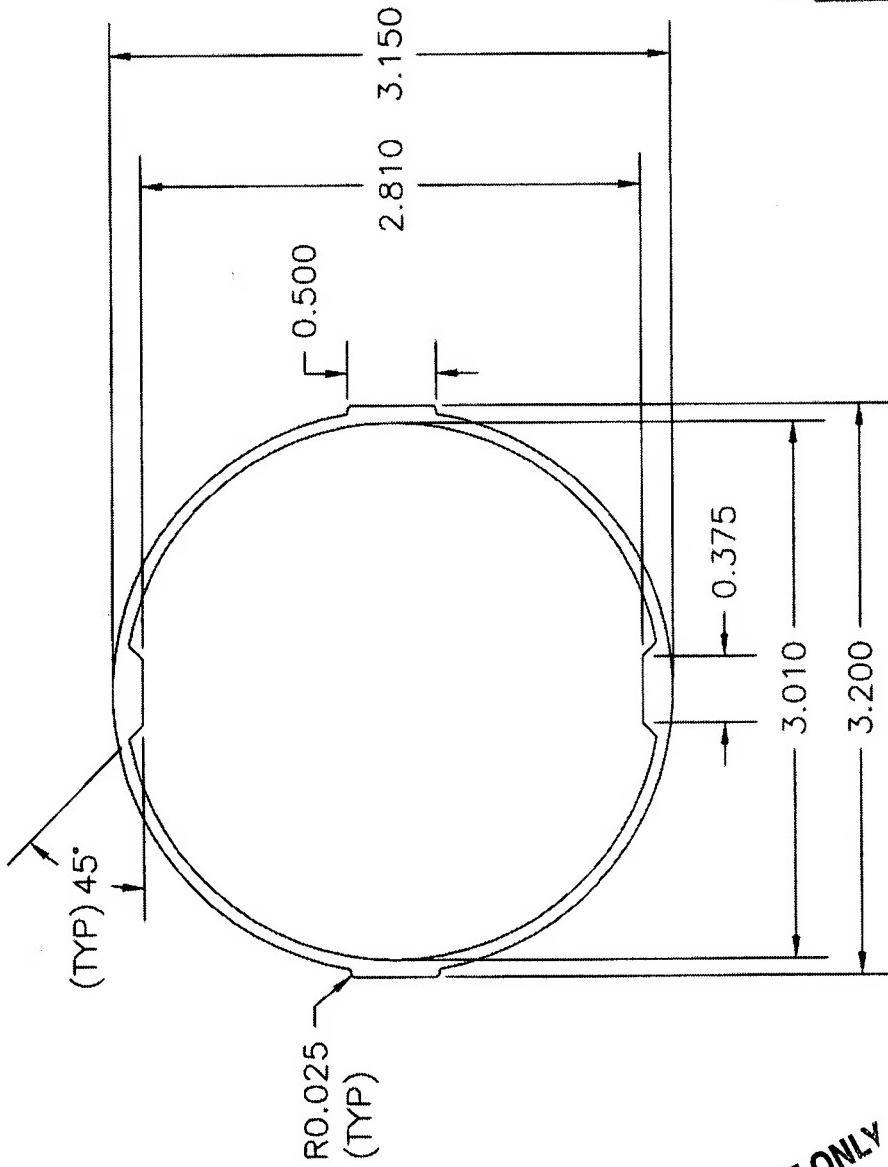
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>BB</i>	DRAWN BY <i>JH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>JH</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DSD2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870

OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

**REFERENCE ONLY**

DART

DESIGN <i>DKY</i>	DRAWN BY <i>DS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>S</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
D1	01.04.17	ADD PART NUMBERS & DIE NUMBERS	+ GP

RELEASED
 4B 08 25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
 MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
 TO ASTM STANDARD B221 BY AN APPROVED TESTING
 FACILITY TO ENSURE THAT THE BATCH MEETS THE
 ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
 NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

REFERENCE ONLY

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

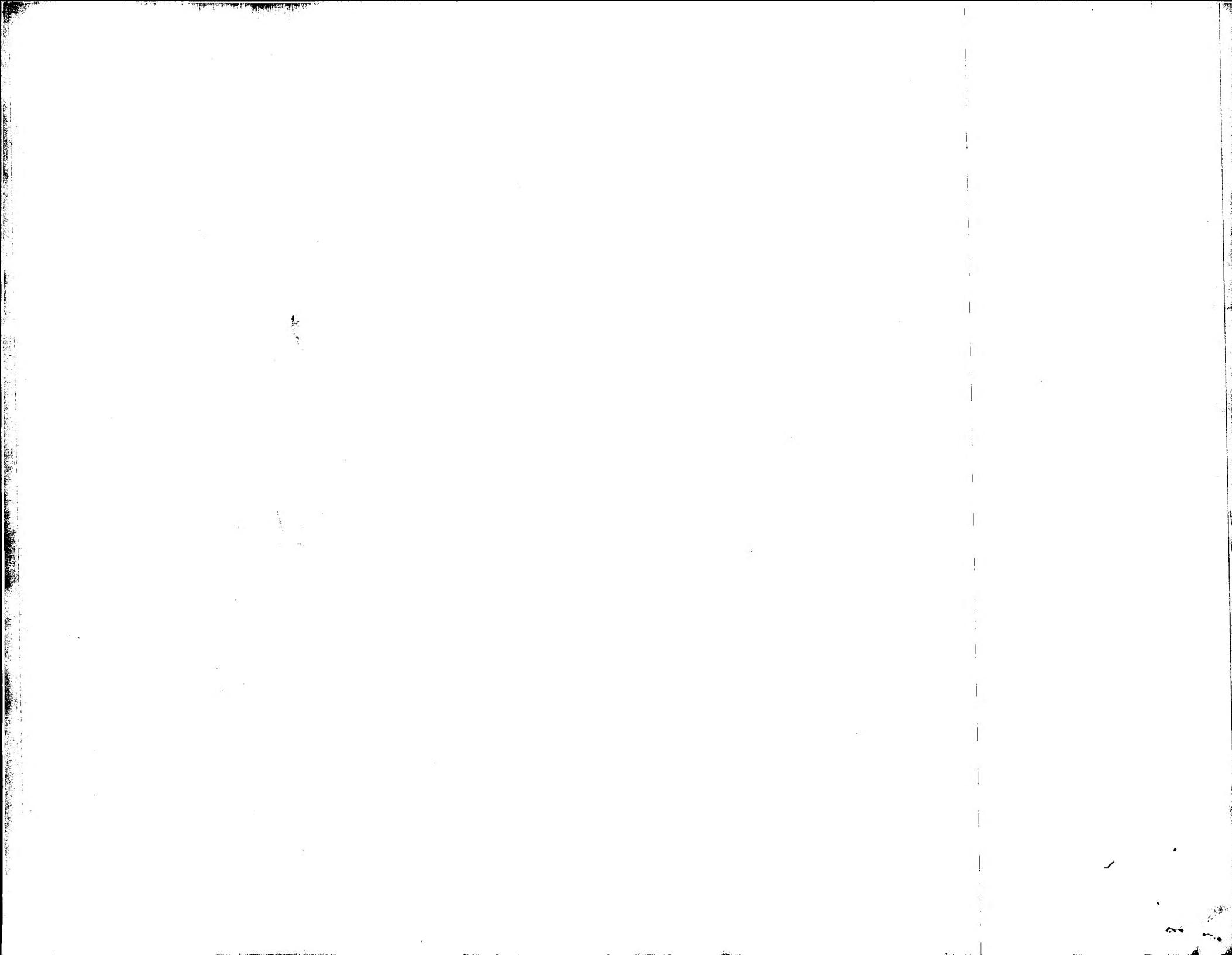
Nov 17, 2005
03:30 pm

Work Order No : 0024841
Project Name : D2600-1-240 Department Code:
Project For : WK550 Burden Flags : NNNNNNNN
Work Order Type : Main WO Status : Open
Main WO Number : Invoice State : Not Invoiced
House Part Number : D2600-1-240 Invoice Date :
Description : Extrusion Round 3" 206 Invoice Number :
Manufactured : Yes Invoice Amount : 0.00
Amount Req'd : 50
Amount Done : 0 Order Entry No :
Start Date : 11-17-05 OE Value : 0.00
Est Finish Date : 12-20-05
Act Finish Date : Est Margin : 0.000%
Drawings Reqd : No Actual Margin : 0.000%
Ok for Approval :
Approval Rec'd : \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00	0.00	0.00
Total Cost :	0.00	0.00	0.00	0.00	0.00
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00

Check By working





BON L CANADA INC

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

CERTIFICATE OF COMPLIANCE

Cert. Date	Cust. No.	Order No.	Page
12/14/05	132184	78944	1
Class	Part No.	Line	Date
173	00287984	78944010	12/14/05

Shipped	Ship To
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No.	Part No.	Item Description	Cart Part
1.000	DAA-897121-2	240" Mill 6061 T6	D2600-1-240
Gross Weight	605 KGS		
Net Wt.	570 KG	59 PC	360 M
Specification:			Dim. Desc.
AMS-QQ-A-200/8 & ASTM B221-00			

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HR-E
1	320.0 / 46.4	291.8 / 42.3	14.3	50	92

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.669	.306	.272	.065	.905	.067	.000	.121	.000	.010	.017	.000	.000
.646	.276	.260	.076	.863	.061	.000	.013	.000	.010	.017	.000	.000
.000	.000	.000	.000	.000	.000	.000	.000	.000	.000	.000	.000	.000
.000	.000	.000	.000	.000	.000	.000	.000	.000	.000	.000	.000	.000

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Ritchie Bisnauth, QA Manager Signed for Bon L Canada